

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013292**Date Inspected:** 15-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yu Dong Ping, Tu Jun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY 11

TOWER STRUT ANGLE CONNECTION PLATE

SAW welding of weld joint 1B located on SD1-SA4-56-123M-3.

Welder is identified as 042195. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-3221-Tc-U5-S-1.

TOWER STRUT FLANGE PLATE

SAW welding of weld joint 3B located on ED1-STSA4-6-131M-2.

Welder is identified as 040699. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-4221-B-U3c-S-1.

WEST TOWER LIFT 5, DE CORNER SEAM

SMAW welding of weld joint 37A located on WSD1-TL5-4B/F.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Welder is identified as 040614. ZPMC QC is identified as Mr. Li Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U4b-1.

WEST TOWER LIFT 5, CD CORNER SEAM

SMAW welding of weld joint 38B located on WSD1-TL5-4B/F.

Welder is identified as 041271. ZPMC QC is identified as Mr. Li Jun.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U4b-1.

WEST TOWER LIFT 4, BC CORNER TRIANGULAR PLATE

FCAW welding of weld joint 87 located on WSTL4-4J/L.

Welder is identified as 053316. ZPMC QC is identified as Mr. Xu Jin Long.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

BAY 10

NORTH TOWER LIFT 5

SMAW welding of weld joint 19B(Repair) located on NSD1-TL5-3B/F.

Welder is identified as 050289. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-485-SMAW-1G(1F)-REPAIR-1.

This QA inspector observed that ZPMC NDT personnel were performing Ultrasonic Testing (UT) on the weld joints SSD1-TL5-1B/F-13A/B & SSD1-TL5-1B/F-21A/B. Non confirming indications were found on both the joints. Attached photographs provide additional details.

PHASED ARRAY ULTRASONIC TESTING (PAUT) TRAINING

This QA inspector attend the Phased Array Ultrasonic Testing (PAUT) training session organized by ASNT level III.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest : 15000422360, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
